

Order # 18695 we have Reminder 19 of 50 Done



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

JAN 13 27
cpl
A.R.C.

D350-591-312
Job Sheet 201571



Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 12/16/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	12/16/19		0.00	10.00	Large Fab - 1		Sta
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	10 pcs	12/16/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18	DAS 24	
							QC 9 - 24	9-89	
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	10 pcs	12/16/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS 24	
							QC 5 - 24	9-89	
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S230209



Part: D350-591-312

Job No: 201571

Serial No/Batch: S230209

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 1 of 1 FAA STC SH96

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					QC 5 - 9						
					QC 5 - 50						
					QC 5 - 30						
					QC 5 - 40						
					QC 5 - 61						
					QC 5 - 81						
					140 Handfinish - 1-1 Chemical-B4B	10 pcs	12/16/19	0.00	1.87	Handfinish - 1 - 1 - B4B	35319-11-12
					Handfinish - 1 - 2 - B4B						
					Handfinish - 1 - 3 - B4B						
					Handfinish - 1 - 4 - B4B						
					Handfinish - 1 - 5 - B4B						
					Handfinish - 1 - 6 - B4B						
					Handfinish - 1 - 7 - B4B						
					Handfinish - 1 - 8 - B4B						
					Handfinish - 1 - 9 - B4B						
					Handfinish - 1 - 10 - B4B						
					Handfinish - 1 - 11 - B4B						
					Handfinish - 1 - 12 - B4B						
					Handfinish - 1 - 13 - B4B						
					Handfinish - 1 - 14 - B4B						
					Handfinish - 1 - 15 - B4B						
					Handfinish - 1 - 16 - B4B						
					Handfinish - 1 - 17 - B4B						
					Handfinish - 1 - 18 - B4B						
					Handfinish - 1 - 19 - B4B						
					Handfinish - 1 - 20 - B4B						
					Handfinish - 1 - 21 - B4B						
					Handfinish - 1 - 22 - B4B						
					150 QC 7	10 pcs	12/16/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13						
					QC 7 - 14						
					QC 7 - 15						
					QC 7 - 17						
					QC 7 - 18						
					QC 7 - 19						
					QC 7 - 2						
					QC 7 - 28						
					QC 7 - 3						
					QC 7 - 30						
					QC 7 - 34						
					QC 7 - 36						
					QC 7 - 37						
					QC 7 - 41						
					QC 7 - 47						
					QC 7 - 48						
					QC 7 - 51						
					QC 7 - 58						
					QC 7 - 59						
					QC 7 - 60						
					QC 7 - 9						
					QC 7 - 68	NOV 13 2019 68					
					QC 7 - 50	9-89					
					QC 7 - 67						
					QC 7 - 40						
					QC 7 - 24						
					QC 7 - 43						
					QC 7 - 61						
					QC 7 - 81						
					QC 7 - 76						
										Plex 10/7/19 3:08 PM Dart.lajeunesse.marie	

				QC 7 - 79	
180 Large Fab - Steps - 2 - B4B	10 pcs	12/16/19	0.00 10.00	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	564
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
190 QC 10	10 pcs	12/16/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	EL
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
200 QC 5	10 pcs	12/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	EL
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 Handfinish - 1-2- Chemical- B4B	10 pcs	12/16/19	0.00 1.87	Handfinish - 1 - 1 - B4B	3EB/9-11-18.
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White Gl(A)- B4B	10 pcs	12/16/19	0.00	2.98		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BZ 19-11-19
						Powdercoat - 4 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	10 pcs	12/16/19	0.00	1.87		Handfinish - 3 - 1 - B4B	21 19-11-20
						Handfinish - 3 - 2 - B4B	
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
						Handfinish - 3 - 5 - B4B	
240 QC 3	10 pcs	12/16/19	0.00	0.00		QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	NOV 21 2019 68
						QC 3 - 9	9-89
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250 Packaging 1-1 - Pick Kit - B4B	10 pcs	12/16/19	0.00	0.00		Packaging 1 - 1 - B4B	✓ Oscar NOV 29 2019
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	
						Packaging 1 - 24 - B4B	

260	QC 4	10 pcs	12/16/19	0.00	0.00	Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
						Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	
						Packaging 1 - 33 - B4B	
						Packaging 1 - 34 - B4B	
						Packaging 1 - 35 - B4B	
						Packaging 1 - 36 - B4B	
						QC 4 - 28	
						QC 4 - 58	
270	Packaging 3-1 - Stock - B4B	10 pcs	12/16/19	0.00	0.00	QC 4 - 69	
						QC 4 - 9	
						QC 4 - 46	
						QC 4 - 68	
						QC 4 - 72	
						QC 4 - 74	
						QC 4 - 75	
						QC 4 - 78	
						Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
275	DC - 1 - B4B	10	12/16/19	0.00	0.00	Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	
						DC - 1 - B4B	

DAS
78
9-89

DEC 09 2019

DAS
78
9-89

DEC 09 2019

DAS
21
9-89

DEC 09 2019

pcs				DC - 2 - B4B	
280	QC 21 - FG	10	12/16/19	0.00 0.00	QC 21 - FG - 21
		pcs			QC 21 - FG - 70
					QC 21 - FG - 53

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds
 130 - QC5- Inspect part completeness to step on W/O
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - QC7-Inspect Chemical Conversion Coat
 180 - Weld per dwg A/R Aluminum rod Batch: _____ 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - QC10- Inspect visual per QSI004- ground welds
 200 - QC5- Inspect part completeness to step on W/O
 210 - Chemical Conversion Coat per QSI005 4.1
 220 - (White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum START TIME: 2:05 OVEN TEMPERATURE: 320°
 FINISH TIME: 2:55
 230 - Wing Walk as per dwg QSI005 4.4 Batch 5229693
 240 - QC3- Inspect Part Finish
 250 - pick kit
 260 - QC4- 100% Inspect kits for completeness
 270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109
 275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001
 280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	⑥ 5220700 / 5229694 ④
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5207455
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	522939
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5230842
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5223196
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5225576
AN3-35A	Bolt	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5225289 ✓
AN4-13A	Bolt	80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5228670 ✓
AN5-36A	Bolt	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5227871 ✓
D2230-3	Mounting Lug	40 pcs (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5225226 ✓
D2618	Bushing	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5216173 ✓
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5212989 (x12) 522315 (x8) ✓
D3235-1	Mounting Lug	20 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5225251 ✓
D3278-041	Support Assembly	10 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5234762 ✓
MS21042L3	Nut	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5218152 ✓
MS21042L4	Nut	80 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5228617 ✓
MS21042L5	Nut	20 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5231232 ✓
NAS1149D0363J	Washer	40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5228336 ✓
NAS1149D0463J	Washer	160 Ea (16 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5225595 ✓
NAS1149D0563J	Washer	40 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	5174288 ✓

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	19	0
	D3219-1	20	123	0
	D3272-1	10	0	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	21	0
	D3066-1	20	68	0
	MS20600-AD4W4	160	819	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	110	0
	AN4-13A	80	614	0
	AN5-36A	20	98	0
	D2230-3	40	201	0
	D2618	20	222	0
	D2856-400-720	20	98	0
	D3235-1	20	98	0
	D3278-041	10	2	0
	MS21042L3	20	3,147	0
	MS21042L4	80	1,489	0
	MS21042L5	20	320	0
	NAS1149D0363J	40	498	0
	NAS1149D0463J	160	2,429	0
	NAS1149D0563J	40	1,159	0
Part Specifications				
Specifications could not be found.				

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



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Instructions: TC STC SH92-6 Issue 10 FAA STC SH967NE 04/12/21, BRAZIL 1